

Work Order ID 93851

Friday, November 23, 2012 7:51:09 AM

93851**RUSH**

Page 1

Item ID: D4457-1

Revision ID: U/R

Item Name: Panel

Start Date: 11/23/2012 Start Qty: 1.00

Required Date: 11/26/2012 Req'd Qty: 1.00

Reference:

Accept

N9000040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

**PRELIMINARY ISSUE**

Approvals:

Process Plan: *mk*

Date: 12-11-22 Tooling:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4457

AUR *PB2*

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *1*Prog Rev: *1**6061* *QD*

2- Deburr if necessary

*(2)**B12-11-23*

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*(2)**B12-11-23*

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Required Date: 11/26/2012 Req'd Qty: 1.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspect to PBZ

120

QC

Memo

0.00

Quality Control

DAS
16
9-89 17/11/23 (2)

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

12/11/22

135

QC7-Inspect Chemical Conversion Coat

0.00

135

QC

Memo

0.00

Quality Control

DAS
16
9-89 inspect to PBZ
Dugay (70)

Work Order ID 93851

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Item ID: D4457-1

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Required Date: 11/26/2012 Req'd Qty: 1.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Bend as per dwg

0.00

150

Brake NC

Memo

0.00

Took 1. for test bend

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

DAS 16 - inspected to PBC
9-88 Dugan
12/14/23 (K)

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

SP
12/14/23

M

Work Order ID 93851

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Item ID: D4457-1

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Item Name: Panel

Start Date: 11/23/2012 Start Qty: 1.00

Required Date: 11/26/2012 Req'd Qty: 1.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

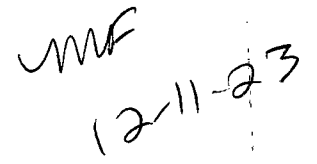
180

QC

Memo

0.00

Quality Control



MF
12-11-23

Picklist Print

Friday, November 23, 2012 7:51:08 AM

Page 1

Work Order ID: 93851

Parent Item: D4457-1

Parent Item Name: Panel

Start Date: 11/23/2012

Required Date: 11/26/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.10.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050 6061-T6 .050 Sheet		Purchased	No			100	sf	382.3160	0.1528	0.1608421			

Location

Loc Qty

Loc Code

MAT021

382.316

114799

28.341

114993

13.5

121192

71.175

123293

269.3

123293

11/23-11-23

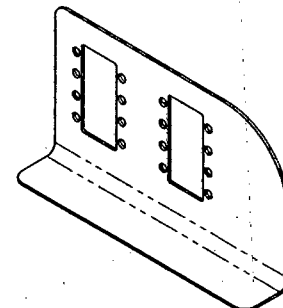
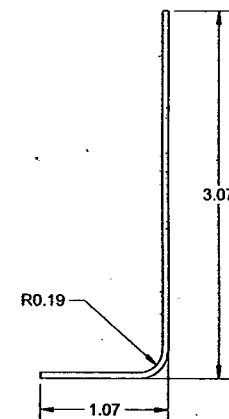
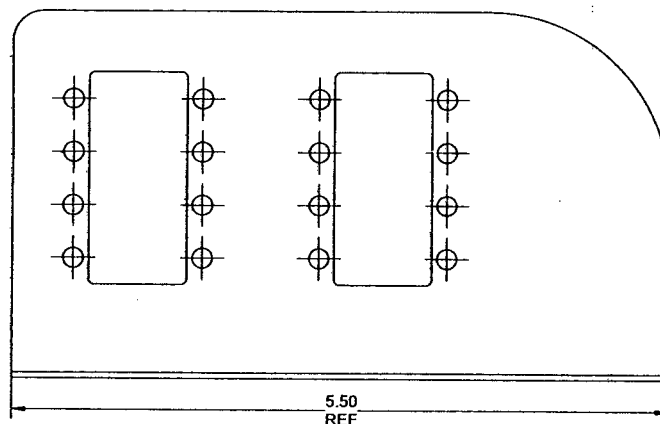
2

D4457-1 PANEL

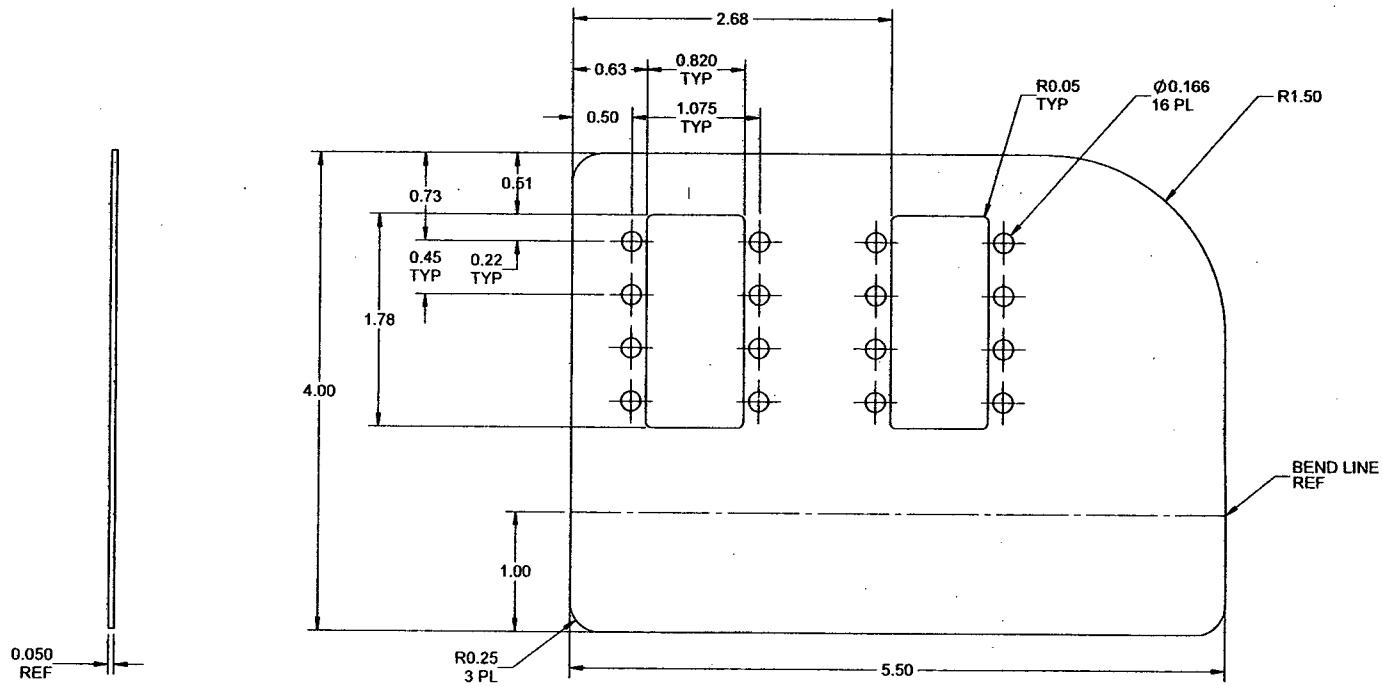


NOTES:

- 1) MATERIAL: MADE FROM D4457-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.09 lbs



PB2	ADD BEND TO FLAT PART (SHT 1)	HS	12.02.13
A	NEW ISSUE	HS	11.10.14
REV.	DESCRIPTION	BY	DATE
DESIGN	RMF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. PB2
MFG. APPR.	HS	D4457	SHEET 1 OF 2
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	PANEL	NTS
DATE	12.02.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4457-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.050 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.050
OR
2024-T3 ALUMINUM SHEET, 0.050 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.050

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

DESIGN	RMF	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PB2
MFG. APPR.	<i>[Signature]</i>	D4457	SHEET 2 OF 2
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	PANEL	NTS
DATE	12.02.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

Receiving Report

Date: 12/10/11
 Supplier: CAMP

Batch No: M123 293
 Dart P/O: 18068

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: DA Yes ☒ No ☐ N/A ☐
 QC6 Inspection 14 12/10/11 N/A ☒
 Work Order 2-89 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 12/10/11
 Date [Signature]
 Received/Costing [Signature]
 Initial [Signature]

Location _____



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO18065**

Purchase Order Date 10/03/12

PO Print Date 10/03/12

Page Number 1 of 2

Order From :

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

VC-CAM002

Contact Name

Vendor Phone 800-667 4248

Vendor Fax 450-377 5696

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

123293

Ship To :

DART AEROSPACE LTD.
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M569EX0.50-18F 018 4	569 Expanded Metal	10/09/12 Yes	128.00 sf	Yours ppd	\$1.0625	\$136.00
		Special Inst: MATERIAL: CARBON STEEL EXPANDED METAL MESH AS PER ASTM F1267 OR MIL-M-17194D					
2	M6061T6S.032 021 4	6061-T6 Sheet 0.032"	10/09/12 Yes	192.00 sf	Yours ppd	\$1.8500	\$355.20
		Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER QQ-A-250/11 OR AMS-QQ-A- 250/11 OR AMS 4025 OR AMS 40327 OR ASTM B209					
3	M6061T6S.050 021 67	6061-T6 .050 Sheet	10/09/12 Yes	288.00 sf	Yours ppd	\$3.0184	\$869.30

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required **YES** NO

Change Nbr: 1

Change Date: 10/03/12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO18065**

Purchase Order Date 10/03/12

PO Print Date 10/03/12

Page Number 2 of 2

Order From :

VC-CAM002

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

Contact Name

Vendor Phone 800 667 4248

Vendor Fax 450 377 5696

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM
SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-
250/11
OR AMS 4025 OR AMS 40327 OR ASTM
B209

PO Total:

\$1,360.50

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 10/03/12

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required **YES** NO

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that sample representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per:

Michael Murphy

Director of Manufacturing Davenport Works

Terence Thom

Quality Assurance Manager

1345958

Ship Date

0

B.L. No.

Invoice No.

Alcoa No. Item

2012-02-21

6796434

00000

1000345769-1

DPE-45769-1

P.O. No./Govt Contract No.

Customer

Alcoa Item

C64614 Ln#: 1

Page 2 of 2

CQR: 0217944.5 -Specification Limits (cont.)

Chemical Composition	Max	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 6061	Min	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	REMAIN

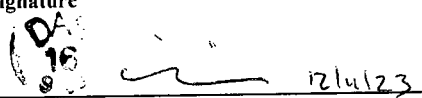
Lot: 391156 - Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	Test	No->	UTS	TYS	ELAD
T6	Long Transv.	7		KSI	KSI	PCT
				50.2	43.8	10.9
				50.3	43.9	11
				50.2	44	10.6
				50.2	43.8	11
				50.4	43.8	11.3
				50.2	43.6	11.4
				49.9	43.4	10.9

Cast Number	Chemical - OBS	SI	FE	CU	MN	MG	CR	ZN	TI
12800482	Actuals	0.66	0.5	0.25	0.13	1.0	0.16	0.01	0.06

This material was melted in the United States or a Qualifying Country (REF DFARS 225.872.1(a)), it was manufactured in the United States



1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE Form One			3. Form Tracking Number: ED-2012-11-23-1	
4. Organizations Name and Address: Dart Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario, K6A 1K7, CANADA Tel: 1 (613) 632-5200 Fax: 1 (613) 632-5246 www.dartaero.com					5. Work Order/Contract/Invoice Work Order 93851	
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial/Batch Number:	11. Status/Work:	
1	PANEL	D4457-1	1	B93851	PROTOTYPE	
12. Remarks: "NOT ELIGIBLE FOR INSTALLATION ON IS-SERVICE TYPE CERTIFIED AIRCRAFT" "THIS ITEM CONFORMS TO DATA THAT IS NOT APPROVED AT THE TIME OF RELEASE, SUBJECT TO APPROVAL OF THE DATA, THE ITEM IS IN CONDITION FOR SAFE OPERATION."						
13a. Certifies that the items identified above were manufactured in conformity to: <input type="checkbox"/> Approved design data and are in a condition for safe operation. <input checked="" type="checkbox"/> Non-approved design data specified in Block 12.			13a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in Block 12. Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12, has been performed in compliance with the <i>Canadian Aviation Regulations</i> .			
13b. Signature 		13c. Approval Organization Number 9-89		14b. Signature		14c. Approved Organization Number
13d. Name Eric Downing		13e. Date (dd/mm/yyyy): 23/Nov/2012		14d. Name		14e. Date (dd/mm/yyyy):
30 Dec 2008(Previously form 24-0078)						
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than the authority specified in Block 1, must ensure that their regulations recognize certifications from the country specified. Statements 13a or 14a do not constitute installation certification. In all cases, the aircraft technical record must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						